

15-06-14

# Work Order ID 133424

Monday, June 08, 2015 4:01:13 PM

**\*133424\***

Page 2

Item ID: D3179-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Litter Tie Down (Non-Locking)  
 Start Date: 6/08/15 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 6/08/15 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                   |
|-----------------------------------------------------|-----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------------------|
| 130<br><b>*130*</b><br>QC<br>Quality Control        | QC8- Inspect parts - second check<br><br>Memo       | 0.00<br><br>0.00     |         |        |              | 4             | ①             |                  | DAS<br>08<br>9-89<br>15/06/15    |
| 140<br><b>*140*</b><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo | 0.00<br><br>0.00     |         |        |              | 4             | ①             |                  | 15/06/15                         |
| 150<br><b>*150*</b><br>QC<br>Quality Control        | QC7-Inspect Chemical Conversion Coat<br><br>Memo    | 0.00<br><br>0.00     |         |        |              | ④             |               |                  | DAS<br>38<br>9-89<br>JUN 15 2015 |

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID                      | Operation<br>Description                                                                                                                                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number   | Insp.<br>Stamp     |
|-----------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|--------------------|--------------------|
| 160<br>*160*<br>Powdercoat<br>Powder Coating        | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br><i>M 131545</i><br>Memo<br>START TIME: <i>2:05</i> OVEN TEMPERATURE:<br><i>300</i> FINISH TIME: <i>2:35</i> | 0.00<br>0.00         |         |        |              |               |               | <i>H φ 15-6-15</i> | <i>DAS 34 9-89</i> |
| 170<br>*170*<br>QC<br>Quality Control               | QC3- Inspect Part Finish<br>Memo                                                                                                                            | 0.00<br>0.00         |         |        |              | <i>4X</i>     |               | <i>15/06/16</i>    | <i>DAS 36 9-89</i> |
| 180<br>*180*<br>Small Fab<br>Small Fab<br>Small Fab | Small Fab<br>Memo<br>Assemble as per Dwg D3179                                                                                                              | 0.00<br>0.01         |         |        |              | <i>4X</i>     |               | <i>15/06/16</i>    | <i>DAS 36 9-89</i> |

*open holes #D .246*  
*DAS 22 9-89 15.06.17*



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 Required Date: 6/08/15 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                        | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                           |
|-----------------------------------------------|-----------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------------------------|
| 190<br><b>*190*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo       | 0.00<br><br>0.00     |         |        |              | (4)           |               |                  | DAS<br>38<br>9-89<br>JUN 17 2015         |
| 200<br><b>*200*</b><br>Packaging<br>Packaging | Identify as per dwg & Stock Location: <u>st 225</u><br><br>Memo | 0.00<br><br>0.00     |         |        |              | 4             |               |                  | DAS<br>27<br>5-89<br>JUN 17 2015         |
| 210<br><b>*210*</b><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo         | 0.00<br><br>0.01     |         |        |              |               |               |                  | MCS<br>JUN 17 2015<br><br>MCS<br>15-6-17 |

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\*133424\*

\*D3179-041\*

Required Qty: 4.00

IPP REV:C

[illegible]

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| GA              | 26             |                 |
| 130573          | 2              |                 |
| 131126          | 6              |                 |
| 131964          | 18             |                 |

|                                    |              |    |     |      |         |    |            |  |
|------------------------------------|--------------|----|-----|------|---------|----|------------|--|
| D2444                              | Manufactured | No | 180 | Each | 16.0000 | 1  | 4          |  |
|                                    |              |    |     |      |         | ** | 15/06/16   |  |
|                                    |              |    |     |      |         |    | 36<br>9-89 |  |
| <b>*D2444*</b><br>Pip Pin Assembly |              |    |     |      |         |    |            |  |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| GA              | 16             |                 |
| 131081          | 9              |                 |
| 131923          | 7              |                 |

|                |              |    |     |   |            |        |   |
|----------------|--------------|----|-----|---|------------|--------|---|
| D6201          | Manufactured | No | 180 | f | 0.0000     | 1.0125 | 5 |
| <b>*D6201*</b> |              |    |     |   | <b>**</b>  |        |   |
| "T" Extrusion  |              |    |     |   | <b>DAS</b> |        |   |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT028          | 0.0000001      |                 |
| 124165          | 0.0000001      |                 |

133208

$$4.08' + 1.042'$$

DAS  
20  
9-89  
15-06-14

# Picklist Print

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Work Order ID: 133424

**\*133424\***

Parent Item: D3179-041

**\*D3179-041\***

Parent Item Name: Litter Tie Down (Non-Locking)

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

180

Each

2,244.000

1

4

**\*MS21042L3\***

**\*\***

Nut

15/06/16  
DAS  
36  
9-89

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

503

M131317

503

ST305

1321

116549

12

126333

49

M128754

2

M132123

258

M132382

1000

4

MS27039-1-13

Purchased

No

180

Each

735.0000

1

4

**\*MS27039-1-13\***

**\*\***

Screw

15/06/16  
DAS  
36  
9-89

Location

Loc Qty

Loc Code

GA

114

124326

114

ST273A

300

124326

300

ST285

321

125654

321

4

NAS1149DO3321

M132189

QTY 12x

15/06/16  
DAS  
36  
9-89

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Shop Packet Print

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|                                                 |               |                             |
|-------------------------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>                       |               | <b>Work Order:</b> 133424   |
| <b>Description:</b> Fwd Litter Tie Down Bracket |               | <b>Part Number:</b> D3179-1 |
| <b>Inspection Dwg:</b> D3179                    | <b>Rev:</b> D | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.00              | +/-0.030      | .999             | ✓      |        | SLOS                 | Vern     |
| Ø0.242            | +0.005/-0.001 | .243             | ✓      |        | gauge pin            |          |
| R0.40             | +/-0.030      | .400             | ✓      |        | Rad gauge            |          |
| 0.375             | +/-0.010      | .377             | ✓      |        | SLOS                 | Vern     |
| Ø0.191            | +0.005/-0.001 | .192             | ✓      |        | gauge pin            |          |
| 1.00              | +/-0.030      | .998             | ✓      |        | SLOS                 |          |
| 1.70              | +/-0.030      | 1.698            | ✓      |        | Height gauge         |          |
| 4.00              | +/-0.030      | 3.997            | ✓      |        | SLOS                 |          |
| 1.50              | +/-0.030      | 1.498            | ✓      |        | "                    |          |
| 0.750             | +/-0.010      | .745             | ✓      |        | "                    |          |
| 1.50              | +/-0.030      | 1.500            | ✓      |        | "                    |          |
| 10.500            | +/-0.010      | 10.500           | ✓      |        | 12" Vern             |          |
| 4.250             | +/-0.010      | 4.250            | ✓      |        | SLOS                 |          |
| 0.750             | +/-0.010      | .747             | ✓      |        | "                    |          |
| 1.000             | +/-0.010      | .998             | ✓      |        | "                    |          |
| 12.00             | +/-0.030      | 12.000           | ✓      |        | 12" vern             |          |
| 1.00              | +/-0.030      | 1.000            | ✓      |        | Height gauge         |          |
| 8.00              | +/-0.030      | 8.000            | ✓      |        | 12" vern             |          |
| Ø0.191            | +0.005/-0.001 | .192             | ✓      |        | SLOS                 |          |
| R0.37             | +/-0.030      | .370             | ✓      |        | Rad gauge            |          |
| 1.875             | +/-0.010      | 1.876            | ✓      |        | SLOS                 |          |
| 0.375             | +/-0.010      | .378             | ✓      |        | "                    |          |
| 2.125             | +/-0.010      | 2.126            | ✓      |        | "                    |          |
| 1.250             | +/-0.010      | 1.250            | ✓      |        | "                    |          |
| 1.00              | +/-0.030      | 1.000            | ✓      |        | "                    |          |
| 3.31              | +/-0.030      | 3.323            | ✓      |        | Height gauge         |          |
| DAS               |               |                  |        |        |                      |          |

|                                |                                                         |                              |
|--------------------------------|---------------------------------------------------------|------------------------------|
| <b>Measured by:</b> 20<br>9-89 | <b>Audited by:</b> <i>[Signature]</i> DAS<br>08<br>9-89 | <b>Preliminary Approval:</b> |
| <b>Date:</b> 15-06-14          | <b>Date:</b> 15/06/15                                   | <b>Date:</b>                 |

| Rev | Date     | Change                           | Revised by            | Approved           |
|-----|----------|----------------------------------|-----------------------|--------------------|
| A   | 09.04.05 | New Issue P/O D3179-041          | KJ/DD                 |                    |
| B   | 12.10.04 | Dimension 0.750 was 1.750        | KJ                    |                    |
| C   | 13.05.27 | Dimensions revised per Dwg Rev D | KJ <i>[Signature]</i> | <i>[Signature]</i> |

